

Fire Red

Dart Aerospace Ltd.

Date: Monday, 09/03/2009 1:46:07 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SLIDING PLATE
Job Number : 46344	
Estimate Number : 11215	
P.O. Number :	Part Number : D33333
This Issue : 09/03/2009 S.O. No. :	Drawing Number : D3333 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 46254	Material :
Written By :	Due Date : 30/03/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUL 09.03.09</u>	
Comment : Est. A05.01.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010B4000X00500

1010-1025 Steel Bar 4.00 x .500

**Comment:** Qty.: 0.7984 f(s)/Unit Total : 3.1937 f(s)

AISI 1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel

(M1010-B4.000x00.500)

Identify for D3333-3

Batch: M10740

J.L 09/03/22

2.0

BAND SAW

BAND SAW

**Comment:** BAND SAW

Cut blanks: 4.000" x 0.500" thick x 9.620" long

J.L 09/03/22

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA483 and Dwg D3333

Identify as D3333-3

J.L 09/03/23

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/03/23

5.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK

J.L 09/03/23 (9)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:46:07 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING PLATE

Job Number: 46344

Part Number: D3333

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Cpl 09.04.14



(X4)

Comment: LARGE FABRICATION RESOURCE 1

Deburr and Grind 45° chamfer on opposite side of pocket along edges as per Dwg D3333

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/04/14

(X7)

8.0

POWDER COATING

POWDER COATING



M 102391



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Ensure to mask threaded holes and sides

START TIME: 11:15am

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:45am

91 09-04-16

(X4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-16

(4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CEN

9/4/17

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22

Job Completion



C209104117

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: H10344
Description: Sliding Plate		Part Number: D3333-3
Inspection Dwg: D3333	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	+/-0.010	3.901	✓			
9.50	+/-0.030	9.500	✓			
0.650	+/-0.010	.650	✓			
2.310	+/-0.010	2.311	✓			
1.125	+/-0.010	1.126	✓			
1.950	+/-0.010	1.951	✓			
1.200	+/-0.010	1.200	✓			
1.300	+/-0.005	1.300	✓			
R0.125	+/-0.010	R.125	✓			
0.500	+/-0.010	.495	✓			
0.440	+/-0.010	.435	✓			
1.675	+/-0.010	1.676	✓			
0.035 x 45°	+/-0.010 x 0.5°	.038 x 45°	✓			
0.485	+0.000/-0.010	.482	✓			
1.11	+/-0.030	1.112	✓			
3/8 - 24 UNF	N/A	3/8-24unf	✓			
0.450	+/-0.010	.446	✓			

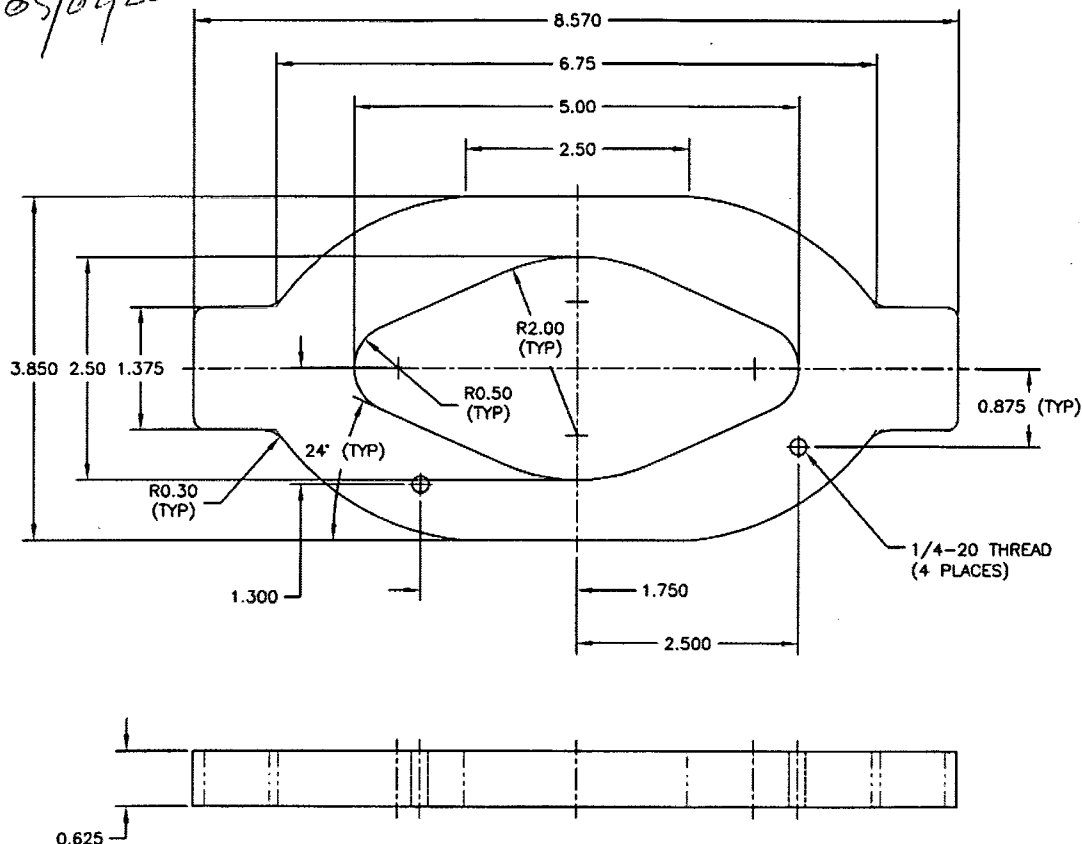
Measured by: JL	Audited by: BP	Prototype Approval: N/A
Date: 08/03/23	Date: 09/03/23	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	BE



DESIGN -H	DRAWN BY -H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED -B	APPROVED <i>[Signature]</i>	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
[Signature]
05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. MIN. YIELD TENSILE STRENGTH = 100 ksi)
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 TO 3. AMENDMENT
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WITHOUT NOTICE
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY

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WORK ORDER

NO. *40344*

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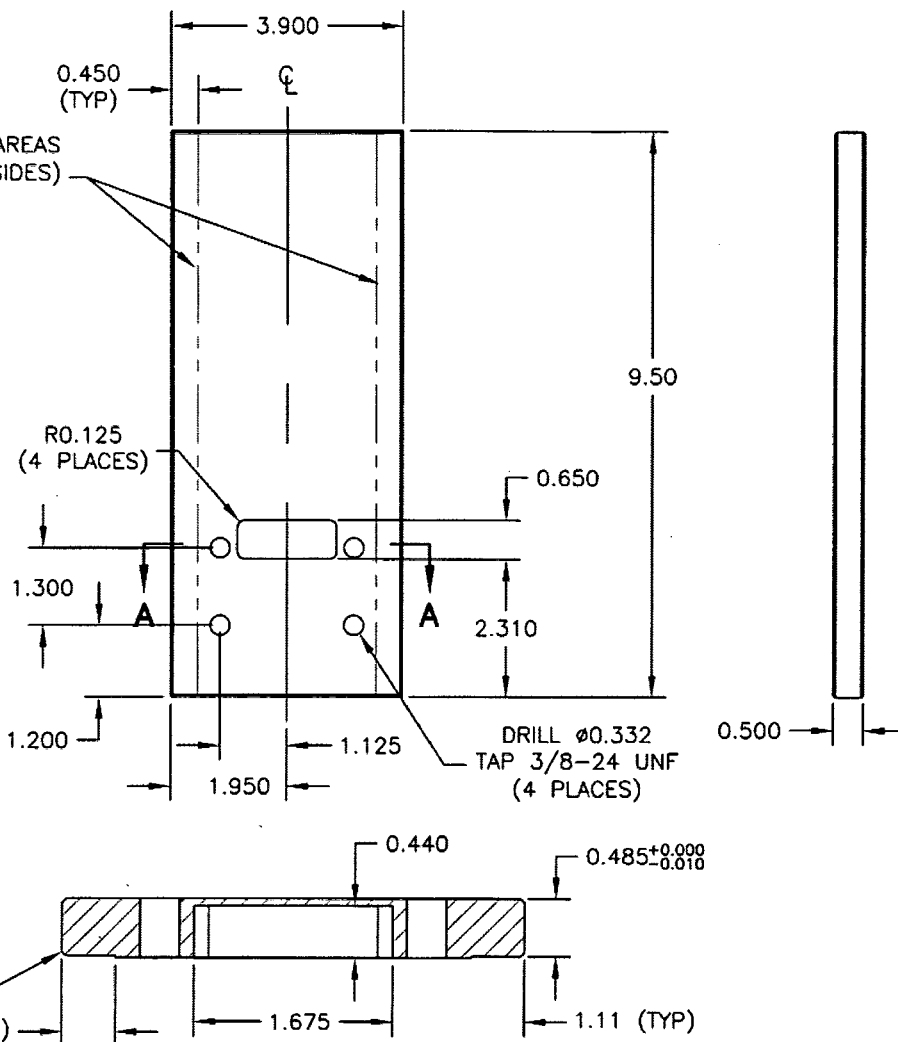
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CHECKED J	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED
05/02/22

DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

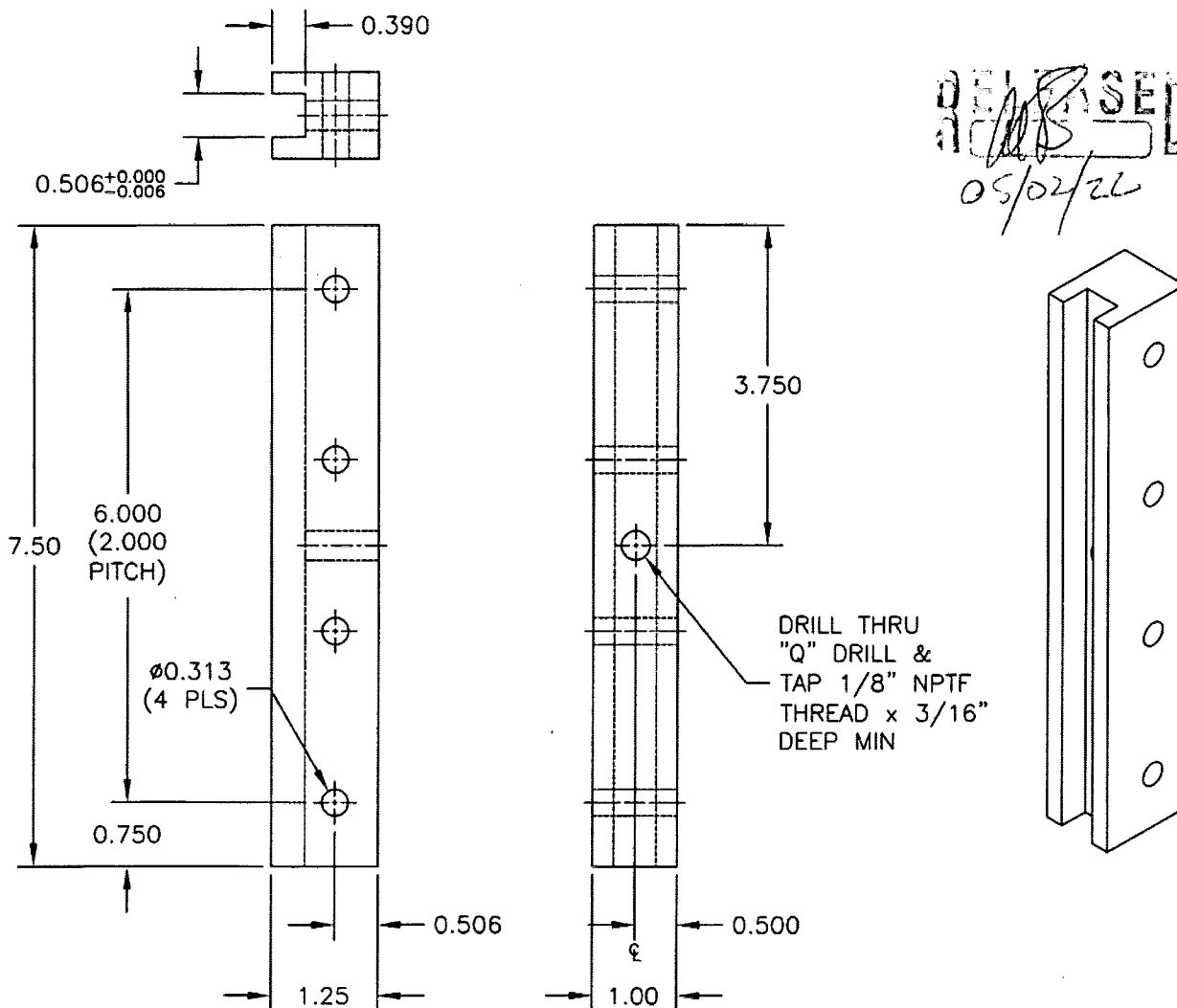
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CHECKED JB	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2



RELEASED
05/02/26

D3333-5 RAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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